

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.yy**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000031**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 16-Dec-2006**Location:** Changxing Island, Shanghai, China**Submittals(New / Total):****CWR's:** 0 / 0**HSR's:** 0 / 0**NCR's:** 0 / 0

Item	Title	Detail
1	Major component movement	<p>Reviewed RT film for PQR 1G Gas Metal Arc Welding (GMAW) procedure test, HP-2006119-5 - ZPMC rejected due to porosity.</p> <p>Performed mechanical testing on 1G Flux Core Arc Welding (FCAW), HP-2006107-7 - tests appear to comply.</p> <p>Conducted welding of the following PQR test plates:</p> <p>1G Gas Metal Arc Welding (GMAW) procedure identified as HP-2006119-6 using Supertech SM-71 electrode to AWS D1.5, Section 5.13 (Production Procedure), note ZPMC has changed to a 65% Argon, 35% CO2 gas mixture.</p> <p>Completed welding of 1G Submerged Arc Welding (SAW) procedure identified as HP-2006130 on 75mm thick HPS 485W material to AWS D1.5, Section 5.13 (Production Procedure). Testing began on 5-13-06.</p>
2	Key conversations	<p>ZPMC Testing Center Director Mr. Liu Liu asked if ZPMC could change the 1G Flux Core Arc Welding (FCAW) procedure identified as HP-2006107-7 to an AWS Section 5.13 (Production Procedure) test plate. It had been initially welded as a 5.12 (Maximum Heat Input) procedure. After consultation with Caltrans Engineer Jim Merrill, it was decided that the actual conducting of the test was similar enough to allow them to vary the parameters within 5.13. Mr. Merrill stressed that ZPMC cannot switch back and forth, but must decide the method they want to vary the procedure and stick with that method. QA relayed this information to ABF Mr. Craig Knops and Mr. Liu Liu.</p>
3	Quality Assurance Inspectors per shift	<p>1 AM 0 PM</p>

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Inspected By: McClary,David

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer